

Work Order ID 92911

November-12-12 3:25:38 PM

92911

Page 1

Item ID: 647.7710

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut Tube

Start Date: 12/11/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 03/12/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: *MLS*

Date: 12-11-12 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

647.7700

N/C

110

0.00

110

12-11-19

Mill Conv

Memo

0.00

Conventional Milling Machine

1- CUT AS PER DWG
2- Mill end of tube as per dwg
3- DEBURR AS PER DWG

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Memo

0.00

Quality Control

130

Identify as per dwg & Stock Location: *ST*

0.00

130

Packaging

Memo

0.00

Packaging

IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV

12/11/18

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Work Order ID 92911

November-12-12 3:25:38 PM

92911

Page 2

Item ID: 647.7710

Revision ID:

Item Name: Strut Tube

Start Date: 12/11/2012 Start Qty: 4.00

Required Date: 03/12/2012 Req'd Qty: 4.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2******4***

Cust Item ID:

4

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/11/20 JF

MF

12-11-20

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Picklist Print

November-12-12 3:25:43 PM

Page 1

Work Order ID: 92911

92911

Parent Item: 647.7710

647 7710

Parent Item Name: Strut Tube

Start Date: 12/11/2012

Required Date: 03/12/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.11.06 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4130NT0.500W.083		Purchased		No		110	f	0.0000	0.82	3.452632			

M4130NT0 500W 083

**

4130 RD tube .500 x .083W

M123724

3.8 ~~12~~ 12-11-19

NCR: Yes / No

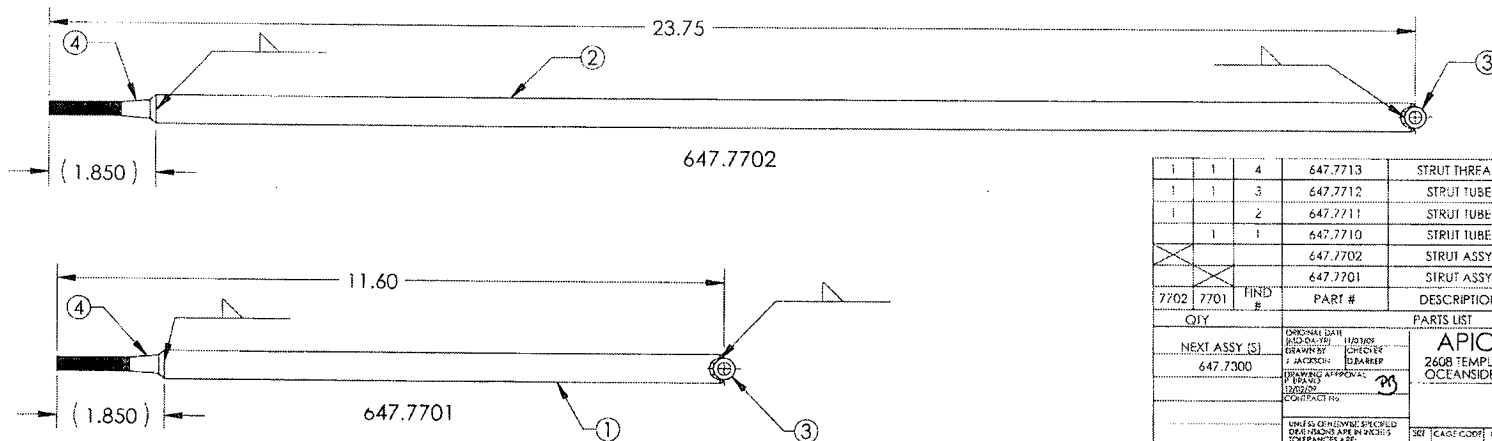
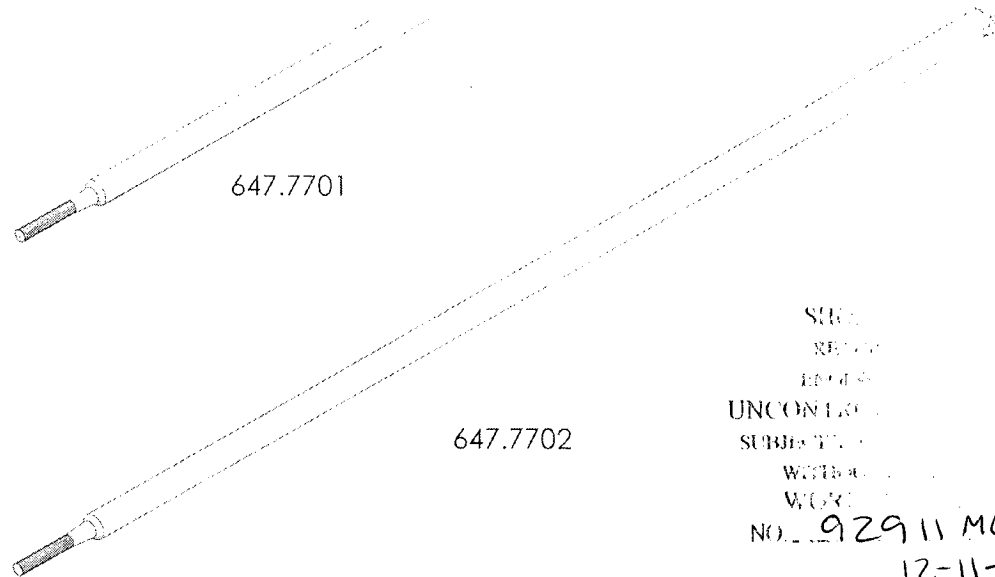
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Training <input type="checkbox"/>											
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1. MATERIAL: 4130 STEEL PER AMS-I-6736, .50" OD, .083" WALL THK.
2. MATERIAL: 4130 STEEL PER AMS-I-6736, .375" OD, .075" WALL THK.
3. MATERIAL: 4130 STEEL PER AMS-I-6736, .324" OD.
4. FINISH: PRIME IAW MIL-P-2337 J TYPE I CLASS N; 1-2 MIL MAX
5. DEBURR AND BREAK ALL SHARP EDGES
6. IDENTIFY IAW MPP-120.
7. WELD IAW MIL-STD-2219, TIG WELD WITH FILLER ROD
8. FINISH: CAD PLATE IAW MIL-C-5541 CLASS 1A
9. MASK THREAD PRIOR TO FINISH



1	1	4	647.7713	STRUT THREAD		
1	1	3	647.7712	STRUT TUBE		
1		2	647.7711	STRUT TUBE		
	1	1	647.7710	STRUT TUBE		
			647.7702	STRUT ASSY		
			647.7701	STRUT ASSY		
7702	7701	HIND #	PART #	DESCRIPTION	MAT'L	SPEC.
QTY			PARTS LIST			
NEXT ASSY (5)			APICAL INDUSTRIES			
647.7300			2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-3300			
			STRUT ASSY			
ORIGINAL DATE 11/27/07 DRAWN BY: J. JACKSON CHECKED BY: J. JACKSON APPROVED BY: J. JACKSON DATE: 11/27/07 SCALE: 1/2" = 1'-0"			100% 			NEW N/C
LISTED AS OF INVENTORY SPECIFIED PARTS VENDORS ARE IN QUOTE'S COMPANIES ARE 1 PLACE IN QUOTE # 1 2 PLACE IN QUOTE # 2015 3 PLACE IN QUOTE # 2015			SET 1 (PAGE CODE) (ROWS PER) B 07PM76 647.7700 SCALE: NONE 1 SHEET 1 OF 2			

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

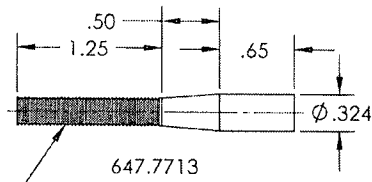
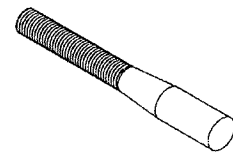
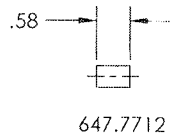
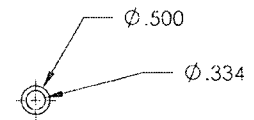
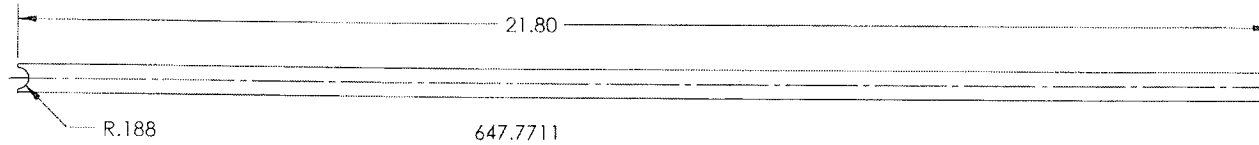
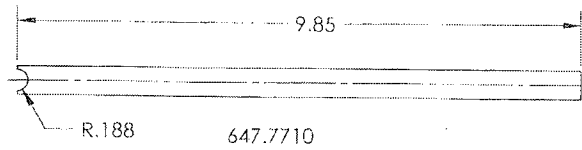
DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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FAULT CATEGORY											
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92911

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1/4 - 28 THREAD

ORIGINAL DATE 11/20/09	APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300				
DRAWN BY: J. JACKSON				CHECKED: P. BRAYD	
DRAWING APPROVAL: P. BRAYD				CONTRACT NO:	
UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°					
REV: 8	DATE: 07/21/16	DWG. NO:	647.7700	REV:	N/C
SCALE: NONE		SHEET		2 OF 2	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

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